

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007116**Date Inspected:** 12-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 6/12/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4 and Foundry at Japan Steel Works (JSW), Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

W2W1 - Casting, having now been completely welded to its plate built up section, is now awaiting for flip to continue its QC Magnetic Particle inspection by Nikko Inspection Services (NIS).

W2W2 - Cast section is in Fabrication Shop #4 having had lugs (4 each) tacked in place, at each end of the casting. The built up plate portion, which is located adjacent its mating casting, is having bevels cut by way of Oxygen and Propane automated rig on tracks. JSW employee, Mr. K. Minami has completed all but 4 ribs plate. This process continued through QA Inspector shift.

W2W3 - Saddle Casting is idle in Foundry. CWI QC Inspector Mr. Makhmud Ashadi randomly verified parameters described in procedure SJ-3011-3 as welder M. Inoue 92-5683 welded joint W3Y-15V with FCAW process and TM95 consumable weld wire.

TOWER SADDLES

T1-2 - QA Inspector noted Tower saddle structure was undergoing grinding of former lifting lug locations. QA Inspector also observed areas for fit up of stiffener plates having been ground in preparation for upcoming fit up of the 50mm plates.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

T1-3 - Nikko Inspection Service (NIS) technician, Mr. R.Kumagai and assistant, M.Sato #81, are testing saddle Complete Joint Penetration CJP welds utilizing shear wave transducer and an A scan display type scope. Couplant appeared to be a oil based lubricant. Approximately 18:00 JSW Engineer, Mr. K.Sato brought to QA Inspector's attention, a defect noted by UT that was classified by NIS technician as a class "C", upon arrival at Fabrication Shop #4, JSW personnel had already ground the indication out and MT'd the excavation. The excavation was determined by QC CWI to be 9mm deep and confirmed by QA Inspector. The Technician's db rating of the indication was "0" and 20mm in length.

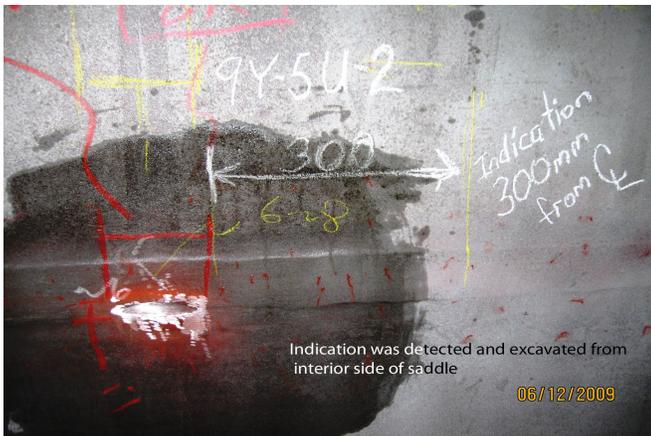
EAST SADDLES

E2E1 - Saddle casting is undergoing defect grinding to excavations to side opposite the ID in the Foundry shop. In Fabrication Shop #4, per QC CWI Mr. C.Kuan, Splay plate cover has had CJP weld of pc mks 21-1 to 21-2, Magnetic Particle tested and Ultrasonic tested by NIS personnel. Results pending report to follow.

E2W1 - Welders, H.Sato 69-2697 and Y.Suzuki 03-2302 are performing weld repair of excavations per procedure SJ-3026-4. Parameters of procedure are being randomly monitored by Weld Engineer Mr. T.Imai in Foundry. In Fabrication Shop #4, welder, Mr. K.Kobayashi 08-5023, was finishing joint on Splay Cover plate #24-1 base to plate 24-2. CJP was being welded with SMAW process and 4mm (followed by 5mm) E7016 electrode. Mr. Chung Fu Kuan, QC CWI, randomly assure compliance to procedure SJ-3177-1. Also in Fabrication Shop #4 is the bearing plate for E2W1, being welded by Y. Watanabe 73-3873, using SMAW process and procedure SJ-3177-4 on blocks identified as pc mk 21-4

West Jacking Saddle has been relocated prior to finish of this side, shaping has resumed in Foundry, 48% complete.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.



Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

your project.

Inspected By: Brcic,Michael

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer